

Work Order ID 103777

June-26-13 8:56:06 AM

\*103777\*

Page 1

Item ID: D3463-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Arm

Start Date: 6/26/13

Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 7/19/13

Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals:

Process Plan:

ML3

Date: 13-06-26

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3463

Rev B

100

0.00

\*100\*

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 25.00" long

10

0

JFL 2013-12-29

105

0.00

\*105\*

Lathe Conv

Memo

0.00

Conventional Lathe

Ream tube at both ends approx 2" deep at .750" Dia

10

0

JFL 2013-12-29

110

0.00

\*110\*

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Bend as per dwg D34632-Trim to length per dwg D34633-Debur

10

14-05-15

JFL

342A

2/11/71

# Work Order ID 103777

**\*103777\***

Page 2

June-26-13 8:56:06 AM

Item ID: D3463-1

Accept

**\*N9000040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Arm

Start Date: 6/26/13

Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 7/19/13

Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Run Start

**\*NR1\***

Stop

**\*NR2\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

27  
9:59  
14/5/13

**\*120\***

QC

Memo

0.00

Quality Control

Ensure 90 deg angle is within tol. (+/-0.5deg) critical dim.

10

130

CONVENTIONAL MILLING MACHINE

0.00

**\*130\***

Mill Conv

Memo

0.00

Conventional Milling Machine

1- Drill as per dwg D3463(One side only)  
2-Deburr as per dwg D3463

10

14-6-10

DAS  
13  
9-89-6

140

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*140\***

QC

Memo

0.00

Quality Control

10

14-6-10

DAS  
13  
9-89

Work Order ID 103777

\*103777\*

Page 3

June-26-13 8:56:06 AM

Item ID: D3463-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Arm  
 Start Date: 6/26/13 Start Qty: 10.00 \*10\* Cust Item ID:  
 Required Date: 7/19/13 Req'd Qty: 10.00 \*10\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00				10	✓		DAS 08 9-89
*150*									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <i>W/1405</i>	0.00				10			14-06-19 <i>MSC</i>
*160*									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
*170*									
QC	Memo	0.00							
Quality Control									

*14-6-19*

# Picklist Print

June-26-13 8:56:06 AM

Page 1

Work Order ID: 103777

Parent Item: D3463-1

Parent Item Name: Arm

Start Date: 6/26/13

Required Date: 7/19/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV. A 05.11.17 NEW ISSUE EC  
LATHE STEP 10-06-02 JLM VER:DD

IPP REV:B ADDED MANUAL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M316TRI.00W.120 316 RD tubing 1.00 x .120w		Purchased	No			100	f	28.0000	2.083	21.926316			

Location

Loc Qty

Loc Code

MAT018

28

121247

28

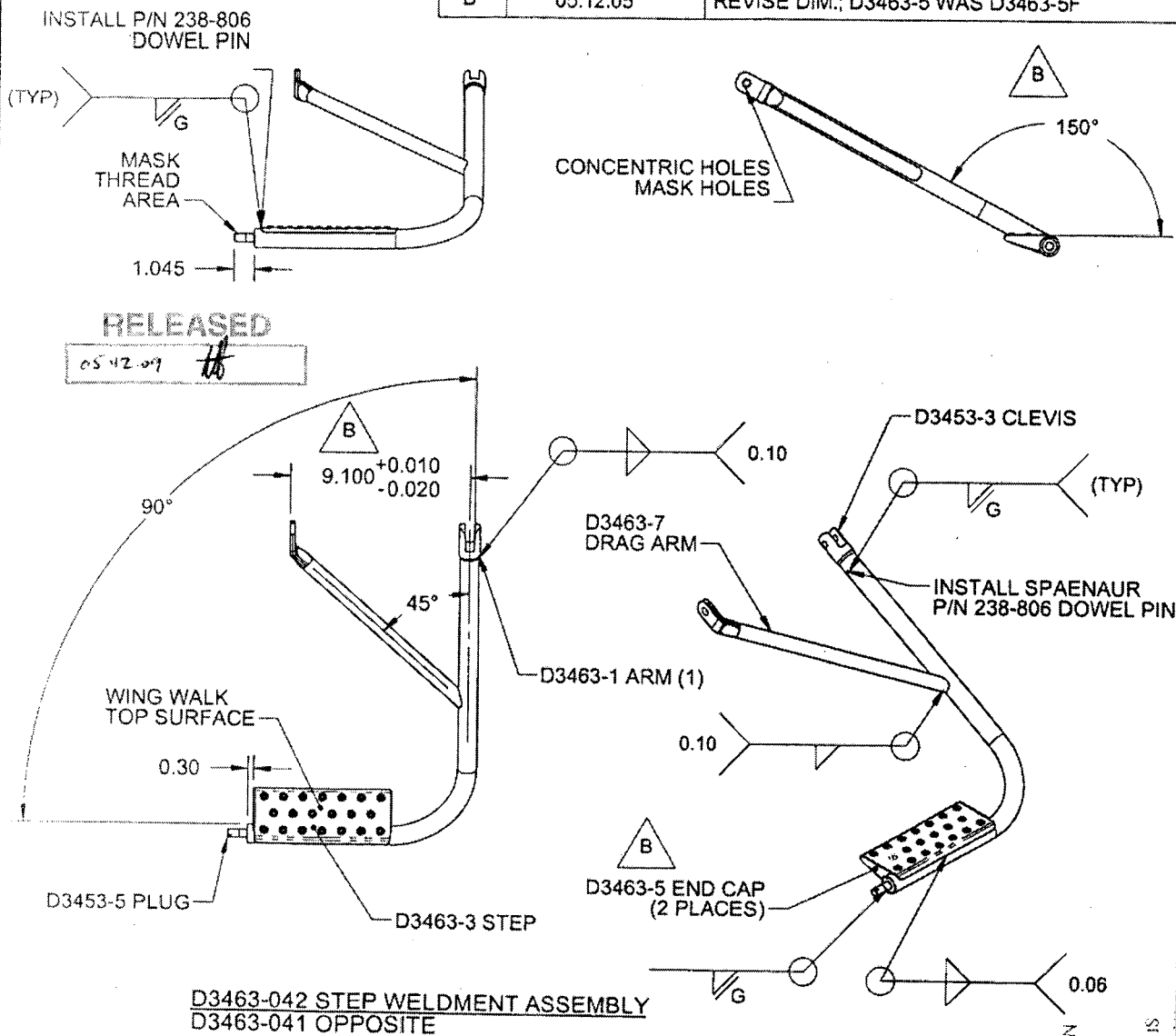
126182

21.926316 Jfe 2013-12-29





DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3463</b>	REV. B SHEET 1 OF 4
DATE <b>05.12.05</b>	TITLE <b>STEP WELDMENT</b>		SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	



**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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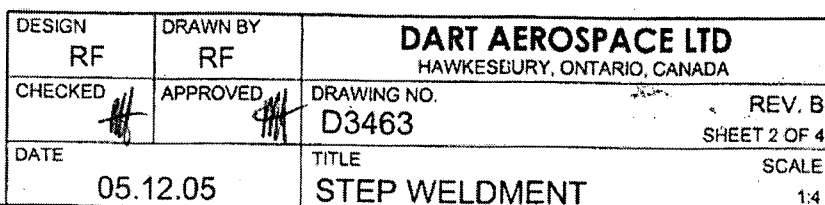
SHOP COPY  
RETURN TO  
ENGINEERING

13-06-26

SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 103777MJS

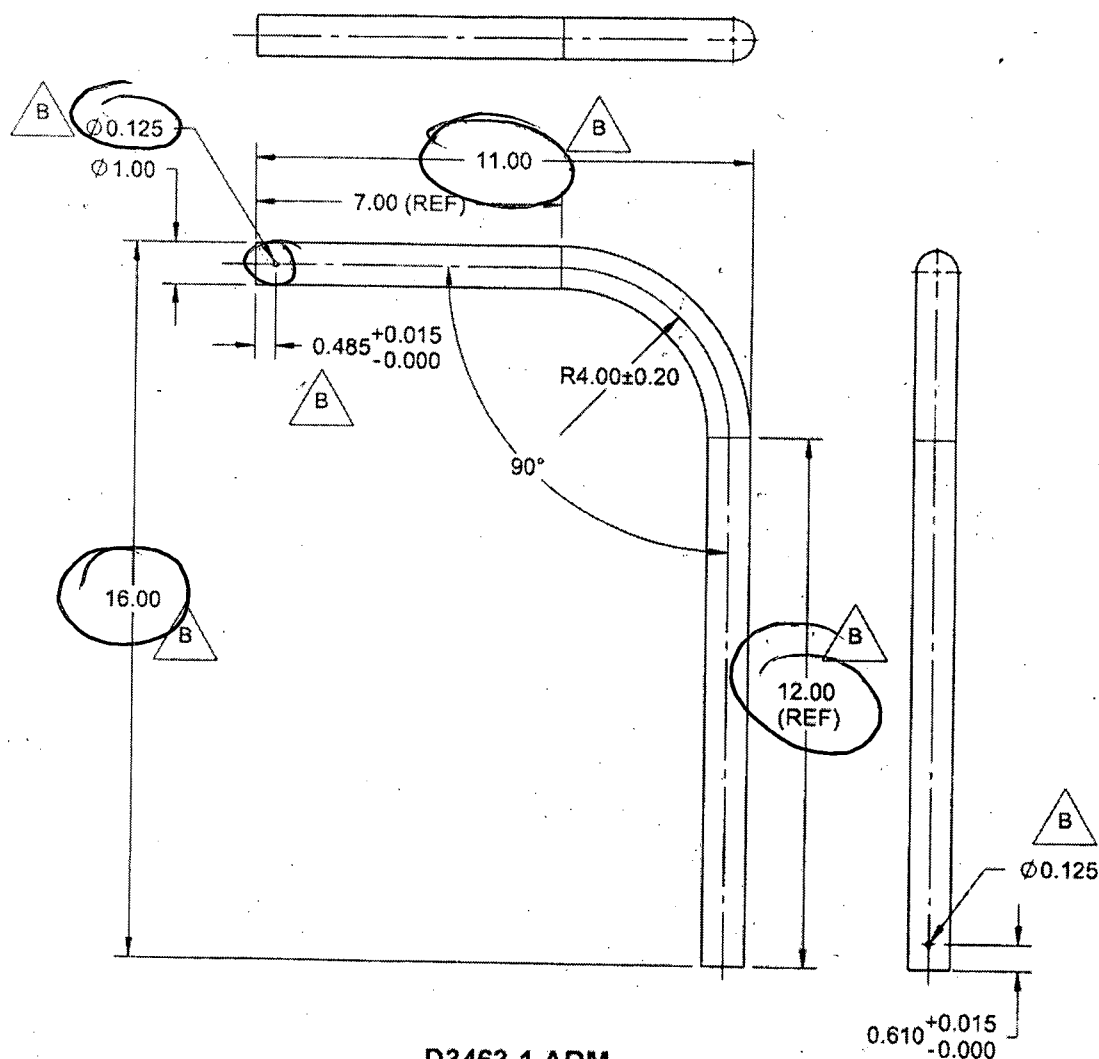






RELEASED

05.12.04



D3463-1 ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)  
2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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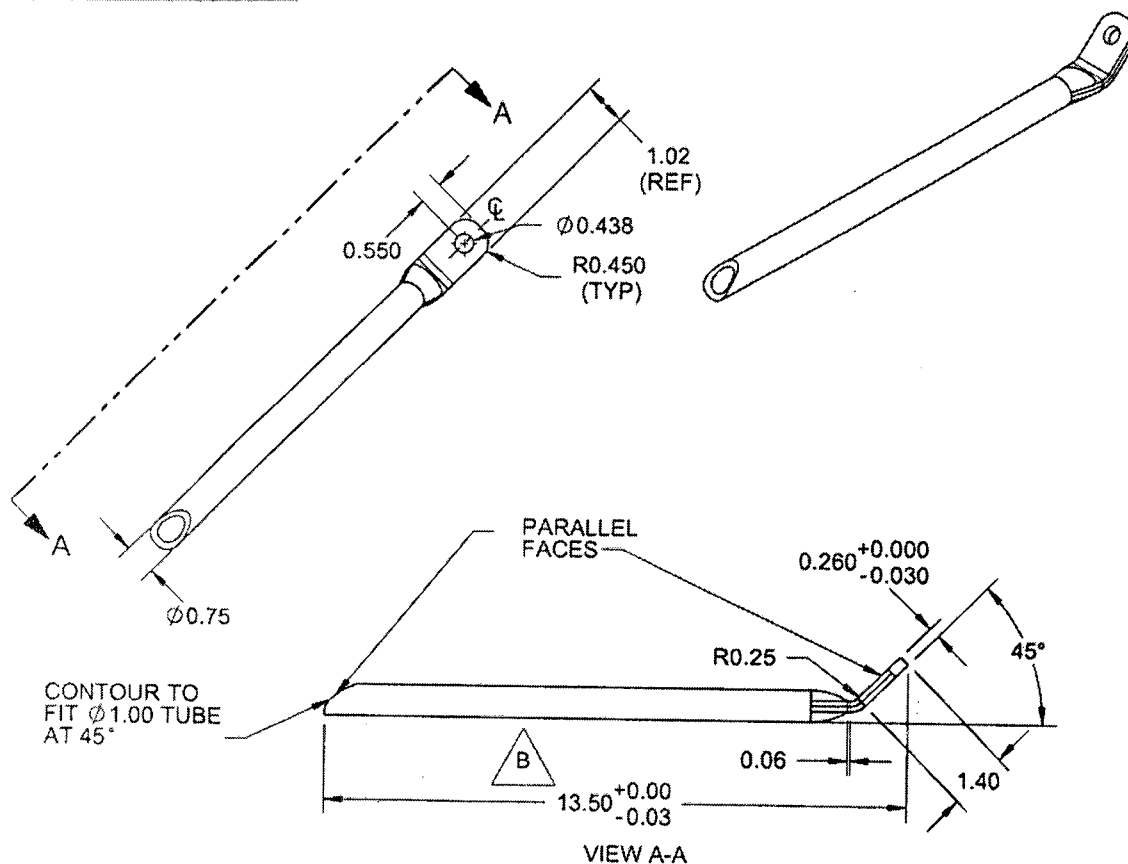
103777



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

05.12.05 #



### D3463-7 DRAG ARM

#### NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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